

Date: Thursday, 9/21/2006 3:13:55 PM  
 User: Kim Johnston

## Process Sheet

<b>Customer</b> :	CU-DAR001 Dart Helicopters Services	<b>Drawing Name</b> :	206B FWD X-TUBE
<b>Job Number</b> :	28679		
<b>Estimate Number</b> :	12346		
<b>P.O. Number</b> :	N/A	<b>Part Number</b> :	D206667101
<b>This Issue</b> :	9/21/2006	<b>Drawing Number</b> :	D206-667-141REV B
<b>Prsht Rev.</b> :	NC	<b>Project Number</b> :	N/A
<b>First Issue</b> :	N/A	<b>Drawing Revision</b> :	B
<b>Previous Run</b> :	26864	<b>Material</b> :	N/A
	<b>Type</b> :	<b>Due Date</b> :	10/15/2006
<b>Written By</b> :	Qty: 1 Um: Each		
<b>Checked &amp; Approved By</b> :	06.09.21		
<b>Comment</b> :	Est Rev:F 06.09.01 Add holes for compatibility with Bell Skidtubes KJ/JLM		

## Additional Product

Job Number:



<b>Seq. #:</b>	<b>Machine Or Operation:</b>	<b>Description :</b>
----------------	------------------------------	----------------------

1.0

DC

DOCUMENT CONTROL

**Comment:** DOCUMENT CONTROL

Photocopy bluefile and create labels as per PPP D206-667-101 CHG002

KS 06.09.28

2.0

D6001105

Crosstube

**Comment:** Qty.: 1.0000 Each(s)/Unit Total: 1.0000 Each(s)

Pick:

Qty Part number Description Batch

1 D6001-105 Crosstube B23965

Check OD = 2.250"; ID = 1.874"

MS 06/09/27

3.0

MORI SEIKI

MORI SEIKI CNC LATHE LARGE

**Comment:** MORI SEIKI CNC LATHE LARGE

1-Fill tube with sand &amp; install plugs DT8534 on both ends as per Folio FA083

2-Turn first side as per Folio FA083

ml 06/09/28

3-Deburr &amp; Inspect for surface damage. Repair damage within limits as per Dwg D206-667-141.

4.0

QC1

INSPECT ALL DIM TO DIM SHEET

**Comment:** INSPECT ALL DIM TO DIM SHEET

ml 06/09/28

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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Drawing Name: 206B FWD X-TUBE

Job Number: 28679

Part Number: D206667101

Job Number:



Seq. #:

Machine Or Operation:

Description :

5.0

MORI SEIKI

MORI SEIKI CNC LATHE LARGE



Comment: MORI SEIKI CNC LATHE LARGE

1-Turn second side as per Folio FA083

2-Deburr & Inspect for surface damage. Repair damage within limits as per Dwg D206-667-141.

3-Polish entire outside surface of crosstube

*DPG-10-2 done at Seq #13*

4-Remove sand and plugs

5-Scribe part # and batch # using vibrating stylus as per Dwg D206-667-141

Inside of Cuff(Donot engrave on outside of tube)

*m.l. 06/09/28*

6.0

QC1

INSPECT ALL DIM TO DIM SHEET



Comment: INSPECT ALL DIM TO DIM SHEET

*m.l. 06/09/28*

7.0

QC8

SECOND CHECK



Comment: SECOND CHECK

*En 06/10/02 01*

8.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

Chemical Conversion Coat as per QSI 005 4.1

*m.l. 06/10/05*

9.0

BENDING

BENDING MACHINE



Comment: BENDING MACHINE

Bend tube as per Dwg D206-667-141 using CNC bender program 206B-fw and Folio FT

*DPG-10-11*

10.0

QC6

DIMENSIONAL CHECK



Comment: DIMENSIONAL CHECK

*Job 10-12*

11.0

LANDING GEAR 1

LANDING GEAR RESOURCE 1



Comment: LANDING GEAR RESOURCE 1

1-Drill pilot holes in tube using drill Jig DT8541 & DT8542 as per Dwg D206-667-141. Drill all (3) top holes.

*FT06  
-10  
-13*

**Dart Aerospace Ltd**

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

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## Process Sheet

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Drawing Name: 206B FWD X-TUBE

Job Number: 28679

Part Number: D206667101

Job Number:



Seq. #:

Machine Or Operation:

Description :

2-Drill & ream holes as per Dwg D206-667-141 using drill Jig DT8575 & DT8576. Drill all (3) top holes.

3-Flip tube and switch drilling Jigs from right to left, left to right. Locate Jigs off existing holes using "T" pins.

4-Drill pilot holes using drill Jig DT8541 & DT8542 as per Dwg D206-667-141. Drill only the top (2) holes.

5-Drill pilot holes as per Dwg D206-667-141. Drill only the top (2) holes.

6-Drill Fwd rivet holes using drill Jig DT8787FWD as per Dwg D206-667-141. *Pm' 06-10-13 ①*  
Note: Fwd side has 3x top holes.

7-Drill Aft rivet holes using drill Jig DT8787AFT as per Dwg D206-667-141. *Pm' 06-10-13 ①*

8-C'sink holes as per Dwg D206-667-141. Allow rivet to sit below surface to compensate for paint. *Pm' 06-10-13 ①*

9-Deburr & Inspect for surface damage. Repair damage within limits as per Dwg D206-667-141 *Pm' 06-10-13 ①*

12.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

*Joe 10-13 ①*

*(PTO)*

13.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

Chemical Conversion Coat as per QSI 005 4.1

*a.m. 06/10/13 ①*

14.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

*Joe 10-16 ①*

15.0

OUTSIDE SERVICE

OUTSIDE SERVICES



Comment: Sub-Contracting OUTSIDE SERVICES

Liquid Penetrant Inspection as per QSI 038Or

Issue P/O: *2246* LPI as per ASTM 1417

Level 2 Attach copy of NDT results to work order

*C206/10/16 ①*

16.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Inspect for transit damage

Ensure copy of NDT results attached to work order.

*Puget 10/18 ①*

# Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			
06-10-13	11.0	Tube drilled as per DSI-9346	PH 06-10-13 per ECN # 840	good see attached DSI.	JP 06-10-13	[Signature] 06-10-13	PH 06-10-13 per ECN # 840	[Signature] 06-10-13

NOTE: Date & initial all entries

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## Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: 206B FWD X-TUBE

Job Number: 28679

Part Number: D206667101

Job Number:



Seq. #:

Machine Or Operation:

Description :

17.0

QC6

DIMENSIONAL CHECK



*Job 10.19.0*



Comment: Inspect for damage & ensure results are as per Dwg D206-667-103

18.0

SPRAY PAINTING

SPRAY PAINTING



Comment: SPRAY PAINTING

1-Prime inside and outside crosstube as per QSI 005 4.2

2-Paint outside crosstube with White Imron as per QSI 005 4.2

*FC 06 10 19 0*

*MA 06 10 19 ①*

19.0

QC14

Inspect Spray Paint



Comment: Inspect Spray Paint

Wrap in plastic bag to protect from scratches

*Job 10.20.①*

20.0

D2856400

Abrasion Strip



Comment: Qty.: 1.2138 f(s)/Unit Total: 1.2138 f(s)

Pick:

Qty Part number Description Batch

2 D2856-400(Cut to 6.94") Abrasion Strip

*B28258 IT 06-10-20*

21.0

D2873043

Nut Plate Assembly



Comment: Qty.: 2.0000 Each(s)/Unit Total: 2.0000 Each(s)

Pick:

Qty Part number Description Batch

2 D2873-043 Nut Plate

*B28075 IT 06-10-20*

22.0

D2873045

Nut Plate Assembly



Comment: Qty.: 2.0000 Each(s)/Unit Total: 2.0000 Each(s)

Pick:

Qty Part number Description Batch

2 D2873-045 Nut Plate

*B28076 IT 06-10-20*

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
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NOTE: Date & initial all entries



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## Process Sheet

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Drawing Name: 206B FWD X-TUBE

Job Number: 28679

Part Number: D206667101

Job Number:



Seq. #:

Machine Or Operation:

Description :

23.0

D28911

Support 2.25 dia



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

Pick:

Qty Part number Description Batch

2 D2891-1

Support

678482

RT

06-10-20

24.0

MS20601AD4W8



Comment: Qty.: 14.0000 Each(s)/Unit Total : 14.0000 Each(s)

Pick:

Qty Part number Description Batch

14 MS20601AD4W8

Rivet

M100771

RT

06-10-20

25.0

MS2192020

Clamp (per MIL-DTL-8783C)



Comment: Qty.: 4.0000 Each(s)/Unit Total : 4.0000 Each(s)

Pick:

Qty Part number Description Batch

4 MS21920-20

Clamp

M15936

IT

06-10-20

26.0

LANDING GEAR 1

LANDING GEAR RESOURCE 1



Comment: LANDING GEAR RESOURCE 1

1-Install abrasion strips as per QSI 035 using DT8579. .Note: (3) top holes should be facing up.

2-Install supports and clamps as per Dwg D206-667-141. Torque clamps to 80-100 in lb

3-Install nut plates as per Dwg D206-667-141. Touch-up rivet heads with Imron paint.

RT  
06-10-20

27.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

Job 10-23 (1)

28.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Pick Packing Kit

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

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Drawing Name: 206B FWD X-TUBE

Job Number: 28679

Part Number: D206667101

Job Number:



Seq. #:

Machine Or Operation:

Description :

29.0

AN532A

Bolt



Comment: Qty.: 4.0000 Each(s)/Unit Total : 4.0000 Each(s)

Bolt

Batch: M102238

30.0

MS21042L5

Nut



Comment: Qty.: 4.0000 Each(s)/Unit Total : 4.0000 Each(s)

Nut

Batch: M101648

31.0

AN57A

Bolt



Comment: Qty.: 10.0000 Each(s)/Unit Total : 10.0000 Each(s)

Pick:Packing Kit

Qty Part number Description Batch

10 AN5-7A Bolt M102140

32.0

AN530A

BOLT



Comment: Qty.: 4.0000 Each(s)/Unit Total : 4.0000 Each(s)

Pick:Packing Kit

Qty Part number Description Batch

4 AN5-30A Bolt M19512

33.0

AN960JD516

Washer



Comment: Qty.: 18.0000 Each(s)/Unit Total : 18.0000 Each(s)

Pick:Packing Kit

Qty Part number Description Batch

10 AN960JD516 Washer M101369

34.0

QC4

INSPECT 100% KITS FOR COMPLETENESS



Comment: INSPECT 100% KITS FOR COMPLETENESS

35.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and pack for shipping as per PPP D206-667-101

Location:

PPP Rev: C

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes ☒ No ☐ DQA: ☒ Date: 26/12/23  
 QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Thursday, 9/21/2006 3:13:56 PM  
User: Kim Johnston

## Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: 206B FWD X-TUBE

Job Number: 28679

Part Number: D206667101

Job Number:



Seq. #:

Machine Or Operation:

Description :

36.0

QC21

FINAL INSPECTION/W/O RELEASE



①

Comment: FINAL INSPECTION/W/O RELEASE

DI 02/10/23

Job Completion



u 06.10.23

**Dart Aerospace Ltd**

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

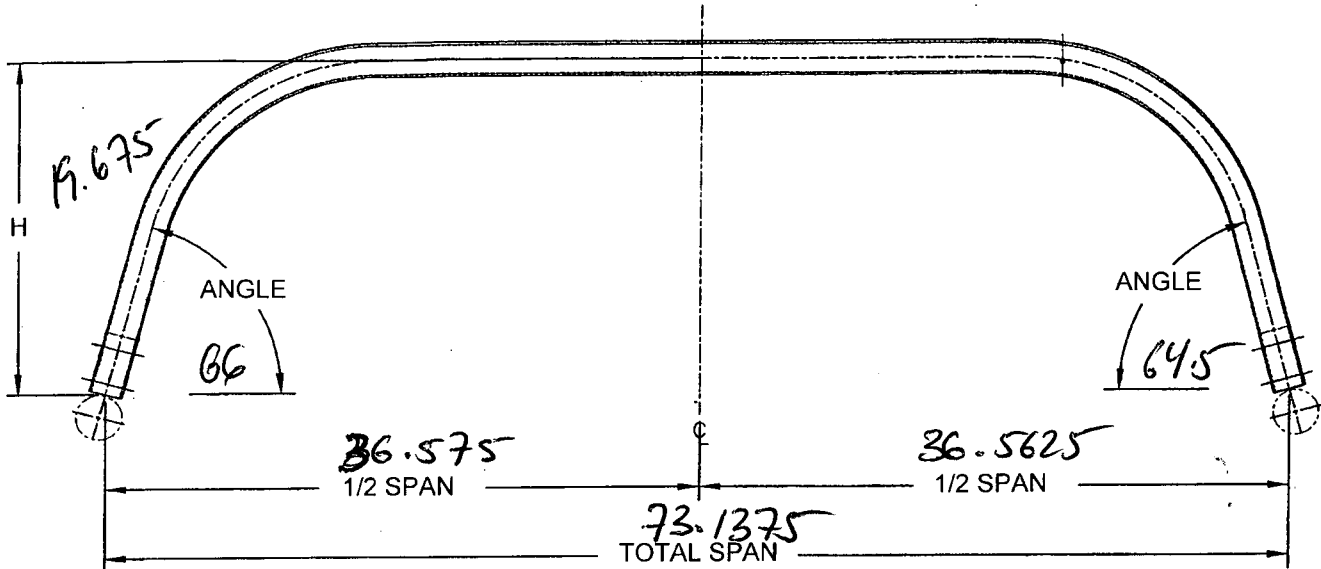
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QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

# Crosstube Bend Dimension Sheet



PART NUMBER: D206-667-101

BATCH NUMBER: 28679

DRAWING: -141 REVISION: B

H: 19.54

1/2 SPAN: 36.60

TOTAL SPAN: 73.2

ANGLE: 65<sup>+2</sup><sub>-0</sub>

QC 15: [Signature]

DATE: 06-10-12

QTY: 1

Height is uneven by  
A max of .100.  
Acceptable, Fits  
Sig very well,



DESIGN PH	DRAWN BY PH	<b>DART AEROSPACE LTD</b> HAWKESBURY, ONTARIO, CANADA	
CHECKED HDS	APPROVED HDS	DRAWING NO. D206-667-141	REV. B SHEET 1 OF 3
DATE 05.07.26		TITLE CROSSTUBE ASS'Y (206B HIGH FWD)	SCALE NTS
A	00.11.17	NEW ISSUE	
B	05.07.26	ADD HOLES AND NUT PLATES FOR COMPATABILITY WITH BHT/AA SKIDTUBES	

RELEASED  
05.07.26

Qty	Part Number	Description
X	D206-667-141	CROSSTUBE ASSEMBLY (206B HIGH FWD)
1	D6001-105	CROSSTUBE
2	D2856-400-694	ABRASION STRIP
2	D2873-043	NUT PLATE
2	D2873-045	NUT PLATE
2	D2891-1	SUPPORT
14	MS20601AD4W8	RIVET (OR NAS9302B-4-8)
4	MS21920-20	CLAMP

#### GENERAL NOTES:

- 1) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED.
- 2) MATERIAL: MANUFACTURED FROM D6001-105  
FINISHED LENGTH = 93.18±0.020
- 3) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1  
PRIME INSIDE AND OUTSIDE PER DART QSI 005 4.2  
PAINT OUTSIDE PER DART QSI 005 4.2
- 4) PART IS SYMMETRIC ABOUT CENTERLINE.
- 5) RUN-OFF PART. BLEND OUT EDGE LONGITUDINALLY, TRANSITION SHOULD BE SMOOTH.
- 6) BEND PROGRESSIVELY WITH A MINIMUM OF 12 PASSES. MAXIMUM TUBE FLATTENING DUE TO BENDING IS 6% BASED ON O.D.
- 7) LIQUID PENETRANT INSPECT OUTSIDE SURFACE OF CROSSTUBE PER QSI 038.
- 8) SCRIBE DART PART NUMBER AND BATCH NUMBER IN THIS AREA WITH VIBRATING STYLUS.
- 9) INSTALL D2856-400-694 ABRASION STRIP WITH A 0.13 (REF) GAP ON BOTTOM SIDE OF CROSSTUBE, CENTERED OPPOSITE D2891-1 SUPPORT, PER QSI 035.
- 10) EXTREME CARE MUST BE TAKEN TO PROTECT THE OUTSIDE SURFACE OF THE TUBE. THE OUTSIDE SURFACE MUST BE SMOOTH AND FREE FROM SURFACE DEFECTS SUCH AS SCRATCHES, NICKS, OR DENTS. DEFECTS UP TO 0.005" MAY BE BLENDED OUT LONGITUDINALLY. CIRCUMFERENTIAL GRIND MARKS ARE UNACCEPTABLE.
- 11) IT IS OPTIONAL TO SEAL EDGES OF SUPPORTS AND ABRASION STRIP USING SIKAFLEX-241/291 SEALANT.
- 12) TORQUE CLAMPS 80 TO 100 IN-LB.

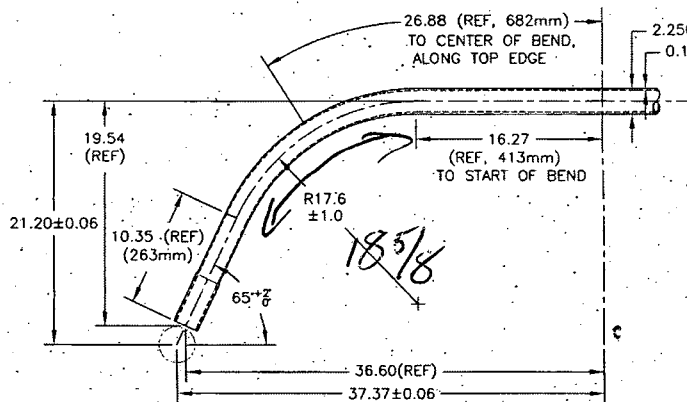
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WITHOUT NOTICE  
WORK ORDER  
NO. 28679

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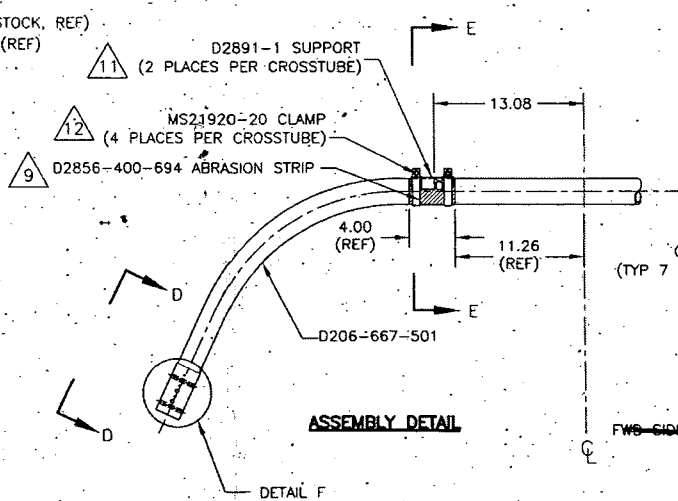
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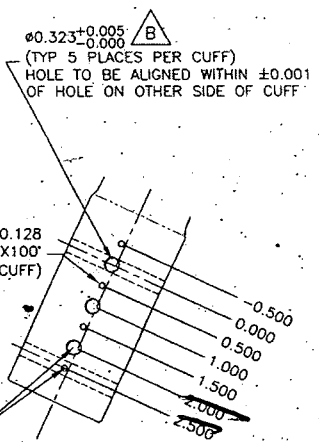




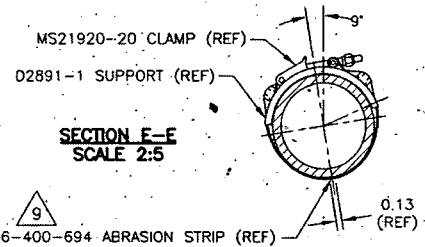
**BENDING DETAIL 6**



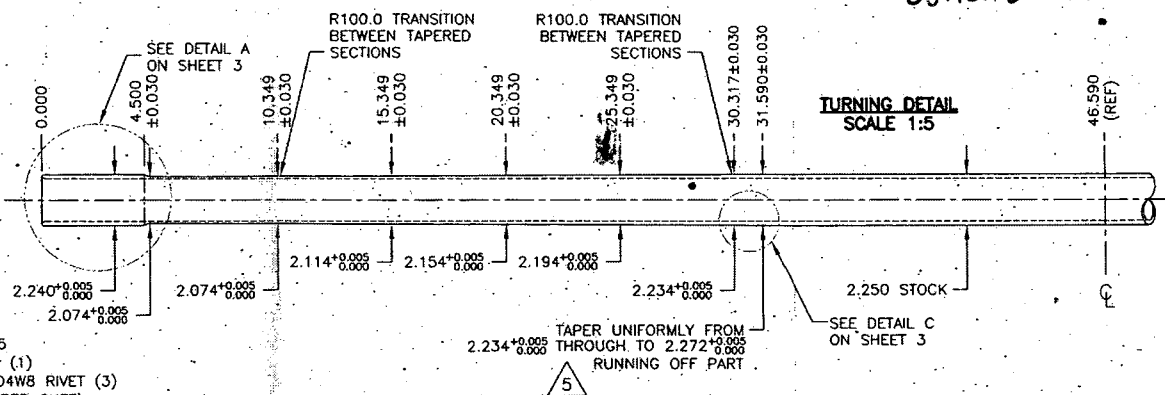
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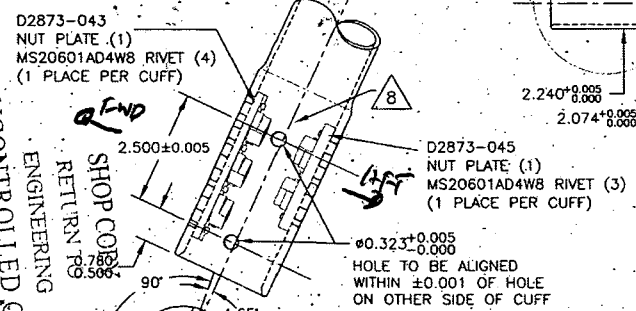
**ALT VIEW PH 06.10.10**



**SECTION E-E SCALE 2:5**



**TURNING DETAIL SCALE 1:5**

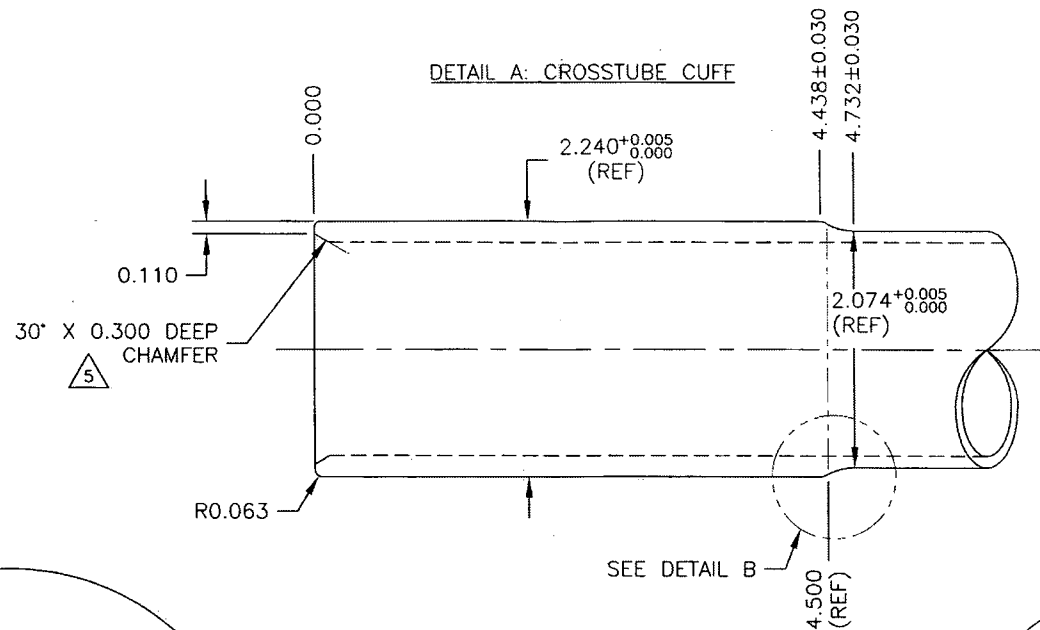


**VIEW D-D: CUFF DETAIL SCALE 2:5**

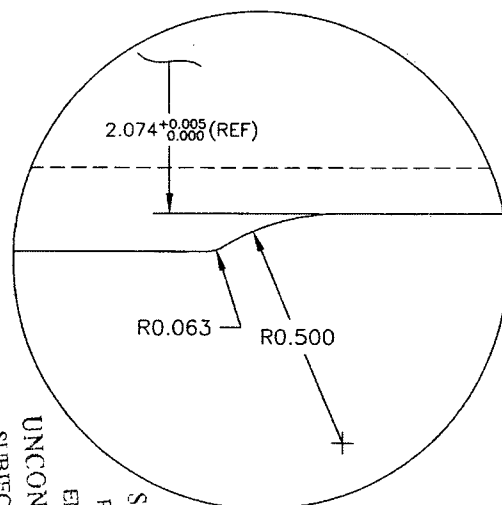
NO. 28679  
WORK ORDER  
WITHOUT NOTICE  
UNCONTROLLED COPY  
ENGINEERING  
SUBJECT TO AMENDMENT

RELEASED  
05.07.26

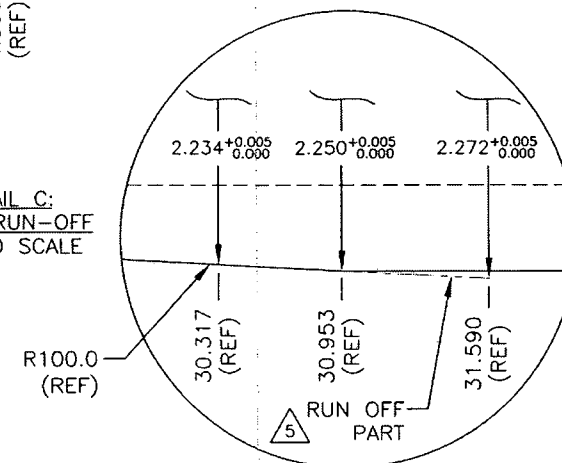
COPYRIGHT © 2000 BY DART AEROSPACE LTD.		DESIGN	DRAWN BY	<b>DART</b> DART AEROSPACE LTD. HAMPSHIRE, OXFORD, CANADA	
THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.		PH	PH	DRAWING NO. 0206-667-141	REV. B SHEET 2 OF 3
DATE 05.07.26		CHECKED DS	APPROVED DS	TITLE CROSSTUBE ASS'Y (206B HIGH FWD) 1:10	



RELEASED  
05.07.26



DETAIL C:  
TAPER RUN-OFF  
NOT TO SCALE



WORK ORDER  
NO. 286279  
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SUBJECT TO AMENDMENT  
WITHOUT NOTICE  
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CHECKED		PH	PH	DRAWING NO.	SHEET 3 OF 3
DATE		05.07.26		D206-667-141	
				TITLE	SCALE
				CROSSTUBE ASS'Y (206B HIGH FWD)	1:1



<b>DART AEROSPACE LTD</b>		<b>Work Order:</b> 28679
<b>Description:</b> Crosstube Assembly		<b>Part Number:</b> D206-667-101
<b>Inspection Dwg:</b> D206-667-141 Rev: B		<b>Page 1 of 1</b>

### FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article
 ☐ Prototype

Inspection Sheet Drawing Dimension		Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
SIDE A	R0.063	± .010	R0.063	-			
	0.110	± .010	0.118	-			
	2.240	+ .005 - .000	2.241	-			
	4.438	± .030	4.440	-			
	2.074	+ .005 - .000	2.077	-			
	2.074	+ .005 - .000	2.079	-			
	2.114	+ .005 - .000	2.118	-			
	2.154	+ .005 - .000	2.158	-			
	2.194	+ .005 - .000	2.199	-			
	2.234	+ .005 - .000	2.239	-			
SIDE B	R0.063	± .010	R0.063	-			
	0.110	± .010	0.118	-			
	2.240	+ .005 - .000	2.241	-			
	4.438	± .030	4.439	-			
	2.074	+ .005 - .000	2.077	-			
	2.074	+ .005 - .000	2.079	-			
	2.114	+ .005 - .000	2.119	-			
	2.154	+ .005 - .000	2.158	-			
	2.194	+ .005 - .000	2.199	-			
	2.234	+ .005 - .000	2.239	-			
	93.18	± .020	93.190	-			

<b>Measured by:</b> <i>ML</i>	<b>Audited by:</b> <i>EP</i>	<b>Prototype Approval:</b>	N/A
<b>Date:</b> 06/09/28	<b>Date:</b> 06/10/02	<b>Date:</b>	N/A

Rev	Date	Change	Revised by	Approved
A		New Issue	KJ/JLM	

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**HeathAir**

INTERNATIONAL (1991) INC.

681 Ave. Lepine, Dorval, Québec H9P 1G3  
Tél.: (514) 636-1000 • Fax: (514) 636-0031

W.O. N° 35067

A.M.O. Number: 46/90

**NON-DESTRUCTIVE TESTING REPORT****AIRCRAFT / COMPONENT INFORMATION**

REGISTRATION: -

MODEL/TYPE: -

SERIAL NUMBER: -

TOTAL HR/LDG: -

OPERATED BY: -

BASED AT: -

**INSPECTION REQUIREMENTS**

Carry out FPI of (5) cross tubes (external surface) as per ASTM E-1417-05 and the Dart QSI 038, Section 4.1.1 (on file at client) - parts delivered to HeathAir.

Qty (1) P/N D206-667-101 Cross tube S/N B28679  
Qty (3) P/N D058-676-201 Cross tubes S/N's B28678, B28677 and B19629.  
Qty (1) P/N D206-667-201 Cross tube S/N B26379.

☐ RADIOGRAPHY☐ ULTRASONIC☒ PENETRANT☐ MAGNETIC PARTICLE☐ EDDY CURRENT**INSPECTION REPORT**

Fluorescent penetrant inspection was performed in accordance with the above requirements on (5) Cross Tubes.

Note: A Level 3 penetrant was substituted for the requested Level 2 (3 is more sensitive)  
Ardrox 970P25E Batch #04B503.

(5) cross tubes inspected. (5) PASSED inspection / (0) FAILED inspection.

THE MAINTENANCE DESCRIBED ABOVE HAS BEEN PERFORMED IN ACCORDANCE WITH  
THE APPLICABLE STANDARDS OF AIRWORTHINESS

INSPECTED BY:

DATE October 17, 2006

INSPECTION  
STAMP(S) **CUSTOMER INFORMATION**

CUSTOMER: Dart Aerospace

P.O. NUMBER 2246 ✓

ADDRESS:

CONTACT NAME: Linda

LABOUR

②

F. 613-632-1053

\$

MATERIALS

②

TRAVEL EXPENSES

②

ATTN: LINDA.

GST

HOTEL EXPENSES

②

PST

INVOICE NO.

TOTAL \$

WHITE COPY - INSPECTION FILE • YELLOW COPY - CUSTOMER • PINK COPY - ACCOUNTANT



DESIGN <i>PH</i>	DRAWN BY <i>PH</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>[Signature]</i>	APPROVED <i>[Signature]</i>	DRAWING NO. DSI 9346	REV. B SHEET 1 OF 1
DATE 06.10.10		TITLE DEVIATION ON D206-667	SCALE NTS
A	06.08.08	NEW ISSUE	
B	06.10.10	ADD B28679, B28682, B28683	

## **DART SERVICE INSTRUCTION**

TO AMEND INSTALLATION INSTRUCTIONS IIN-D206-667 REV. C

REF. CANADIAN STC: SH01-5

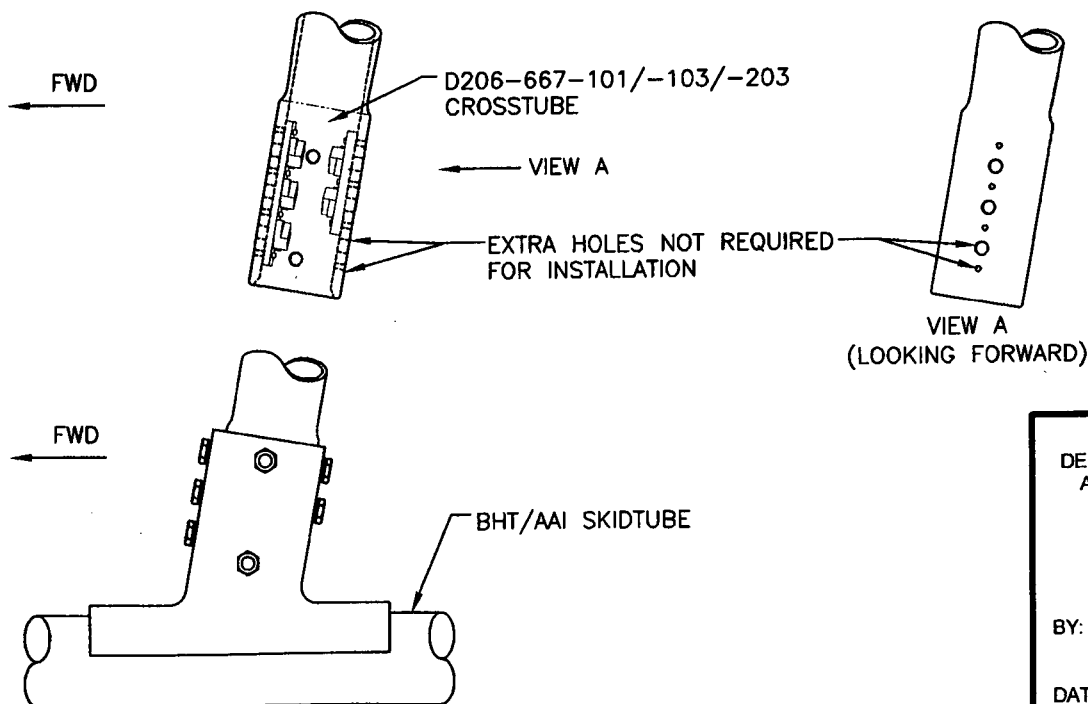
REF. FAA STC: SR01304NY

THE FOLLOWING D206-667-101/-103/-203 CROSSTUBES HAVE EXTRA HOLES DRILLED ON THE AFT SIDE OF THE CUFFS. THIS HOLE IS NOT REQUIRED FOR INSTALLATION OF DART CROSSTUBES ONTO BHT/AAI SKIDTUBES AS SHOWN IN FIGURE 1.

CUSTOMERS RECEIVING CROSSTUBES AT CHG 002 PRIOR TO 06.08.08 SHOULD CONTACT DART FOR DISPOSITION IF INSTALLING THE DART CROSSTUBES ONTO BHT/AAI SKIDTUBES PER IIN-D206-667 REV. C.

CUSTOMERS RECEIVING CROSSTUBES AT CHG 002 PRIOR TO 06.08.08 TO BE INSTALLED WITH DART SKIDTUBES MAY FIND THAT THE SUPPORTS HAVE BEEN INSTALLED BACKWARDS. THE SUPPORTS SHOULD BE REMOVED AND RE-INSTALLED PER ICA-D206-667.

PART NO.	CHANGE NUMBER	BATCH NO
D206-667-101	002	B24244, B28679
D206-667-103	002	B26702, B26704, B27980, B25606, B25605, B23220, B23219, B23218, B23217, B28682, B28683
D206-667-203	002	B27492, B27491, B27981, B25609, B25608, B25006, B24646



**FIGURE 1** - INSTALLATION OF DART CROSSTUBES ON BHT/AAI SKIDTUBE

CANADA DEPARTMENT OF TRANSPORT AIRCRAFT CERTIFICATION BRANCH DAO # 01-O-01	
<b>APPROVED</b>	
BY:	<i>[Signature]</i> D. SHEPHERD (DE # 02)
DATE:	06.08.08
CERT. NO.:	SH01-5
ISSUE NO.:	3

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